

Date: Wednesday, 11/21/2007 12:50:32 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HANDLE  
 Job Number : 35935  
 Estimate Number : 11212  
 P.O. Number :  
 This Issue : 11/21/2007 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 1 / Type : LARGE FAB ASSY  
 Previous Run : 35489  
 Written By :  
 Checked & Approved By : 11/21/2007  
 Comment : Est: B 05.06.20 Holes no longer made by machine KJ/JL  
 M

Part Number : D33321  
 Drawing Number : D3332 REV A1  
 Project Number : N/A  
 Drawing Revision : A1  
 Material :  
 Due Date : 12/5/2007 Qty: 15 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M1018R2000 1018-1025 Steel Bar



Comment: Qty.: 0.0218 f(s)/Unit Total: 0.1310 f(s)  
 1018-1025 Steel Bar  
 Material: AISI 1018-1025 Ø2.00" Round Bar  
 (M1018-R2.000)  
 Identify for D3332-1  
 Batch: m116639

H.A 08/01/06

15

2.0 HARDINGE HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL  
 Turn as per Folio FA494 and Dwg D3332

H.A 08/01/06

15

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/01/06

15

4.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
 Drill as per Dwg D3332 and Deburr using D3338-041-T1  
 Identify as D3332-1

H.A 08/01/31

15

5.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/01/31

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: D Date: 08/05/01  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:32 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 35935

Part Number: D33321

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 86

8/1/31 SD 15x

7.0

QC21

FINAL INSPECTION/W/O RELEASE



15

Comment: FINAL INSPECTION/W/O RELEASE

D0810261

Job Completion



C20810131

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

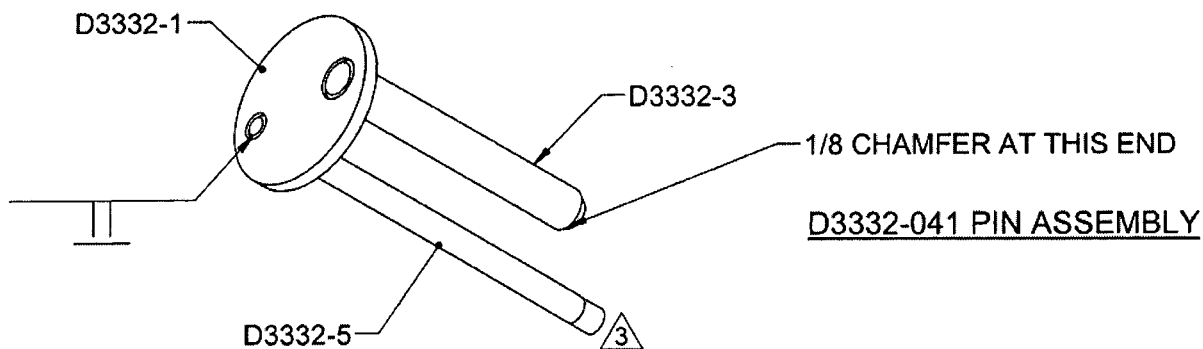
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



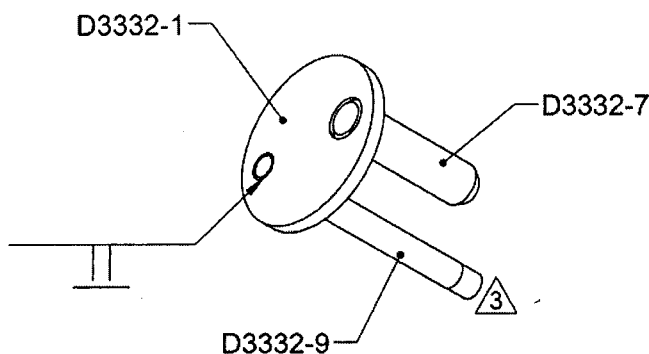


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE $\pm 0.000$ $\pm 0.005$	



D3332-041 PIN ASSEMBLY

RELEASED  
*[Signature]*  
05/02/09



D3332-043 PIN ASSEMBLY

**NOTES:**

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3  
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

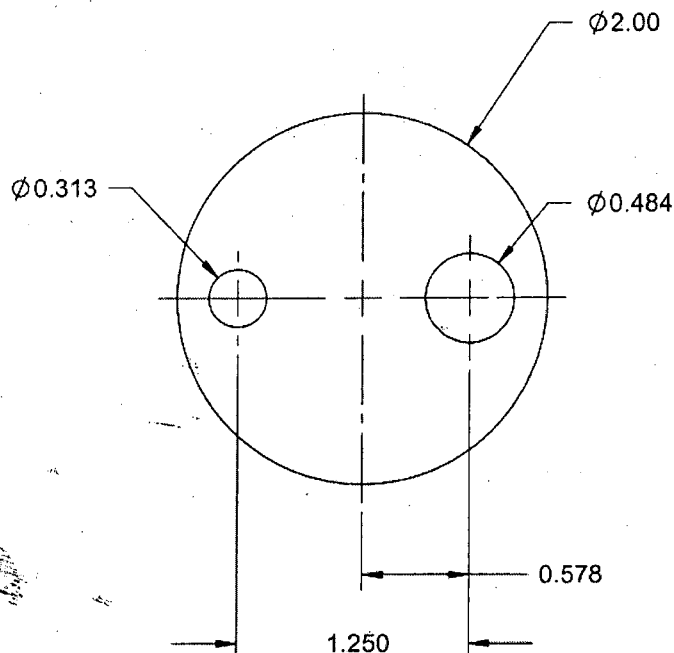
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DATE <b>04.12.14</b>		TITLE <b>PIN ASSEMBLY</b>	SCALE 1:1



**RELEASED**  
*[Signature]*  
2/02/09

243  
156  
399

**D3332-1 HANDLE**

**NOTES:**

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

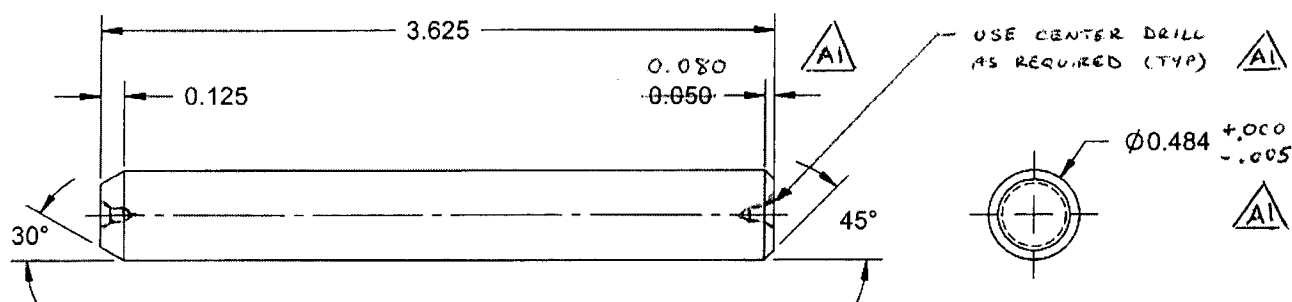
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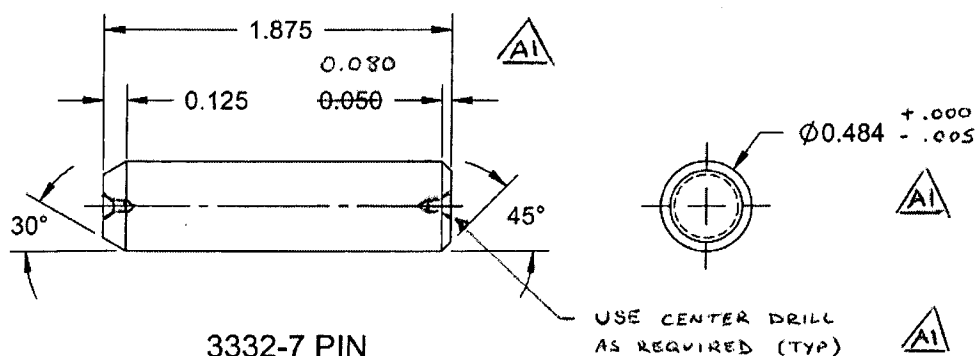


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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

**RELEASED**  
*[Signature]*  
05/02/09



3332-7 PIN

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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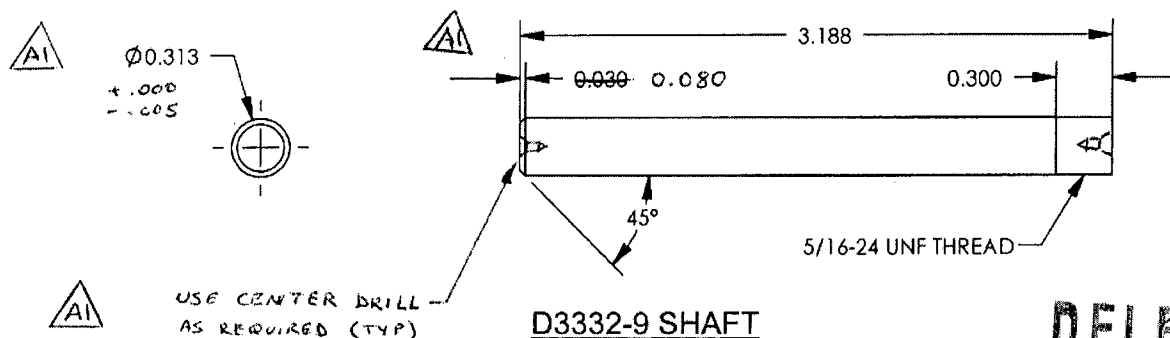
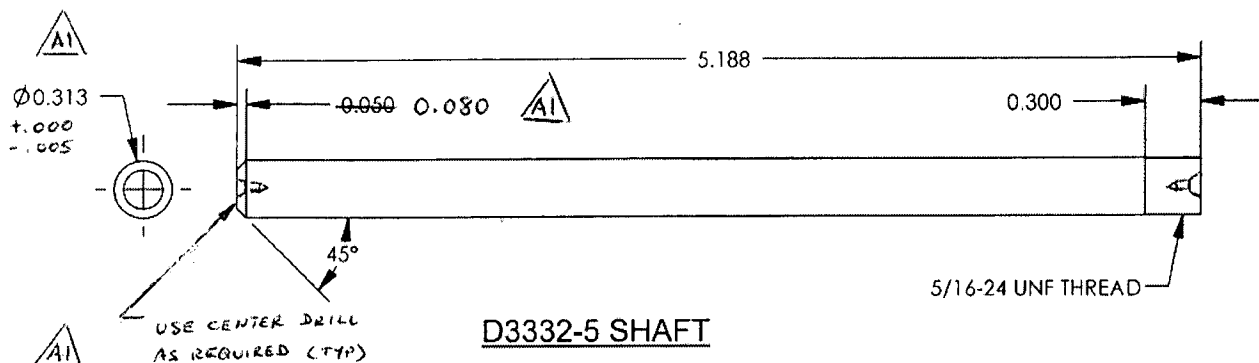
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DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



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*[Signature]*  
05/02/09

**NOTES:**

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097  
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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